

Date: Thursday, 2/23/2006 10:23:56 AM
User: Kim Johnston

Process Sheet

Split

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BRACKET ASSEMBLY
Job Number : 25920-1
Estimate Number : 10334
P.O. Number : N/A Part Number : D2804042
This Issue : 2/23/2006 S.O. No. : N/A Drawing Number : D2804 REV B
Prsht Rev. : NC Project Number : N/A
First Issue : N/A Type : R & D SM/MED FAB Drawing Revision : B
Previous Run : 23627 Material : N/A
Written By : SEE COMMENT BELOW Due Date : 3/22/2006 Qty: 8 Um: Each
Checked & Approved By : JF 06.02.23
Comment : Est F 05.03.30 MS21043-3 was MS21042L3 KJ/JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D28042 STA 155 Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)
STA 155 Bracket

Pick:

Qty	Part Number	Description	Batch
1	D2804-2	Bracket	B25714 (8)

2.0 D28052 Stop



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)
Stop

Pick:

Qty	Part Number	Description	Batch
1	D2805-2	Stop	B21306 (8) SAD 06.03.01 8

3.0 D2809 Bushing



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)
Bushing

Pick:

Qty	Part Number	Description	Batch
1	D2809	Bushing	B22529

4.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Press D2805-2 into arm as per Dwg D2804

SAD 06.03.02.02 8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 2/23/2006 10:23:56 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 25920

Part Number: D2804042

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06-03-02

6.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

a.m 06-03-06

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

ml 06 03 06 (8)

8.0

AN3C16A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Bolt

Pick:

Qty

Part Number

Description

Batch

2

AN3C16A

Bolt

17944
M 17073

9.0

MS210433

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Nut

Pick:

Qty

Part Number

Description

Batch

2

MS21043-3

Nut

M 19099

10.0

NAS1515H3

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 40.0000 Each(s)

Washer

Pick:

Qty

Part Number

Description

Batch

4 NAS1515H3

Washer

M 17994

A/R

LPS-3

Corrosion Spray

M 17045

SB 06/03/02

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06-03-02	8	Press Fit D2809 bushing before ASS'y. AS Rev Dwg 2804 per merant change UACB	<i>[Signature]</i>	06-03-02		<i>[Signature]</i>	<i>[Signature]</i> 06-03-02

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/03/08
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 2/23/2006 10:23:56 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 25920

Part Number: D2804042

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Spray LPS-3 on Bolt Shaft, not on thread as per Dwg D2804

2-Assemble as per Dwg D2804.

SB 06/03/07

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

2060307

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 57156

6/3/8 (8)

14.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DD 06/03/08

Job Completion



6 06-03-08

~~D 101 NAS 1515 HB WASHER x 4 A1799W~~

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

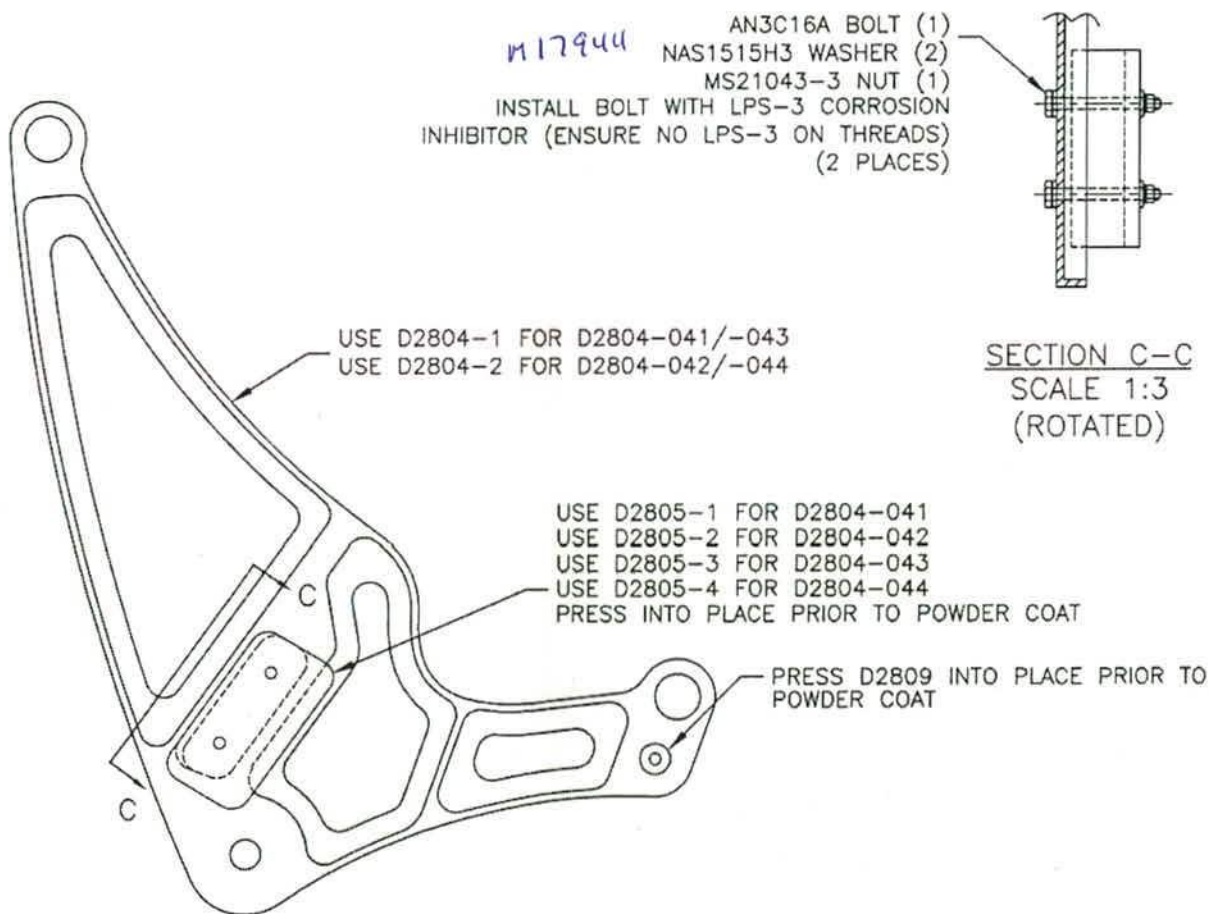
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD
				HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. D2804
				REV. B SHEET 2 OF 2
DATE	04.11.22	TITLE	STA 155 BRACKET	SCALE 1:3

**RELEASED**05-03-11 *[Signature]*SHOP COPY
RETURN TO
ENGINEERING
CONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *25920*

D2804-041/-043 BRACKET ASS'Y (SHOWN).
D2804-042/-044 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

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